

Date: Thursday, 17/01/2008 3:13:10 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEB		
Job Number	: 36871			Part Number	: D2739		
Estimate Number	: 10498			Drawing Number	: D2739 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 17/01/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LANDING GEAR	Due Date	: 24/01/2008		
Previous Run	: 36683			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	:			Est Rev: C 02.11.28 Reformat KJ			
				Est Rev: D 06-03-21 As Per Rev C JLM			
				Est Rev: E 07-07-28 As per Rev D JLM Verified By:			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web <u>B 29985</u> <u>10</u> <u>M</u> <u>8-1-17</u>		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1	
1-Cut D2600-5 to length as per Dwg D2739.	
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	
3-Use uni-bit to open holes to finish size as per Dwg D2739.	
4-Bevel Fwd end of extrusion and Deburr holes and ends.	
5-Dburr	
3.0 QC5.	INSPECT WORK TO CURRENT STEP
<b>Comment:</b> INSPECT WORK TO CURRENT STEP	
<u>8-1-21</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>Alum 08-01-23</i>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
6.0	PACKAGING 1	PACKAGING RESOURCE #1
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*A.m 08.01.23*

Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock  
Location: L.6

(1)

K

8 - 1 - 23

Job Completion



*2008/1/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

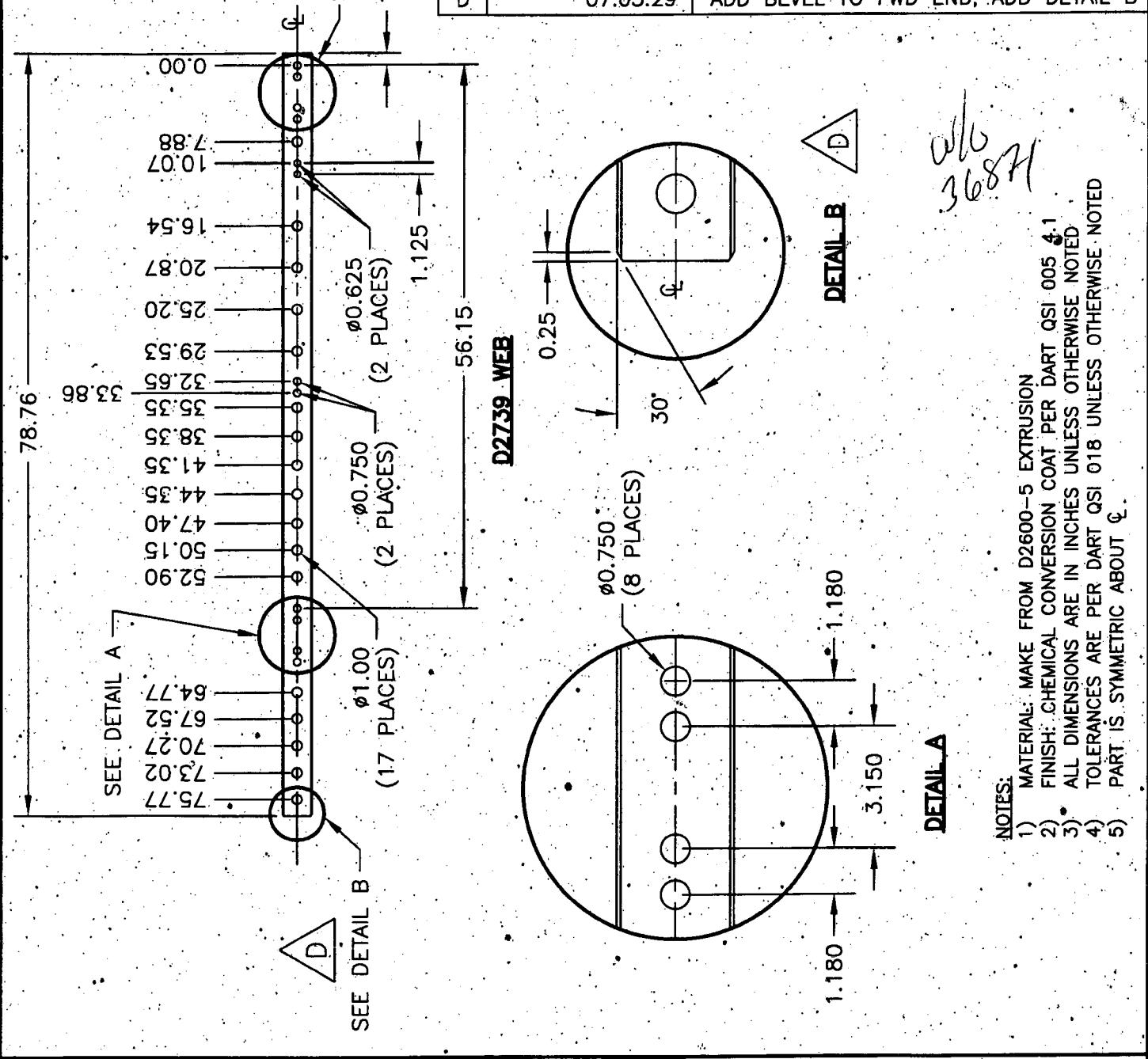
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

**RELEASED**  
07.05.29

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA.
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D2739
DATE 07.05.29		TITLE WEB
		SCALE 1:15
A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B



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